

POLY(ARYLENE ETHER) COMPOSITIONS

CROSS REFERENCE TO RELATED APPLICATIONS

The application claims priority to U.S. Provisional Application Serial No. 60/319,980 filed on February 28, 2003, which is incorporated by reference herein.

BACKGROUND OF INVENTION

[0001] This disclosure relates to poly(arylene ether) compositions with a combination of low melt viscosity and high heat deflection temperature.

[0002] Poly(arylene ether) resins are an extremely useful class of high performance engineering thermoplastics by reason of their hydrolytic stability, high dimensional stability, toughness, heat resistance and dielectric properties. They also exhibit good mechanical performance and high glass transition temperature values, typically in the range of 150° to 210°C. This unique combination of properties renders poly(arylene ether) based compositions suitable for a broad range of applications. Poly(arylene ether) polymers typically have relatively high molecular weights and possess high melt viscosity with intrinsic viscosity values typically greater than about 0.3 dl/g, as measured in chloroform at 25°C.

[0003] It is desirable to improve the melt viscosity capability of poly(arylene ether) compositions. Melt viscosity capability is the ability of a composition to flow freely at elevated temperatures during various processing stages such as extrusion and molding. The melt viscosity can impact the size and type of part that can be prepared with the composition. It has been suggested to improve the melt viscosity of poly(arylene ether) compositions by decreasing the molecular weight of the poly(arylene ether) polymers; however, lower molecular weight sometimes adversely affects other properties such as impact strength. Alternatively, poly(arylene ether) compositions are often prepared with flow promoters or plasticizers such as polystyrene, particularly crystal polystyrene, saturated polyalicyclic resins and terpene phenol to impart high flow to the resulting composition. Polystyrene, terpene phenol and other such flow promoters reduce the heat deflection temperature (HDT) of the

product. Additionally, some flame retardants also act as plasticizers and increase the melt viscosity capability.

[0004] Efforts to improve the flow characteristics of poly(arylene ether) resins with minimal or no loss of HDT values and impact properties have been made. One approach calls for the addition of a resinous additive comprising vinyl aromatic monomers or a hydrocarbon containing at least 35 weight percent (wt%) aromatic units.

[0005] Other approaches have included compositions comprising a blend of two or more poly(arylene ether) resins with one resin having a high intrinsic viscosity values and the other having low intrinsic viscosity. While these approaches have been promising, they have been primarily directed to compositions containing significant amounts of flame retardant and/or plasticizer which has impacts the heat deflection temperature.

SUMMARY OF INVENTION

[0006] A poly(arylene ether) composition comprises a first poly(arylene ether) resin having an intrinsic viscosity greater than or equal to about 0.3 dl/g, as measured in chloroform at 25°C and a second viscosity poly(arylene ether) resin having an intrinsic viscosity less than or equal to about 0.17 dl/g, as measured in chloroform at 25°C wherein the composition is essentially free of plasticizers.

[0007] In another embodiment a poly(arylene ether) composition consists essentially of a first poly(arylene ether) resin having an intrinsic viscosity greater than or equal to about 0.3 dl/g, as measured in chloroform at 25°C and a second viscosity poly(arylene ether) resin having an intrinsic viscosity less than or equal to about 0.17 dl/g, as measured in chloroform at 25°C.

BRIEF DESCRIPTION OF THE FIGURES

[0008] Figure 1 is a graph depicting melt viscosity data.

[0009] Figure 2 is a graph depicting heat deflection temperature data.

[0010] Figure 3 is a graph depicting heat deflection temperature data.

[0011] Figure 4 is a graph depicting melt viscosity data.

[0012] Figure 5 is a graph depicting melt viscosity data.

DETAILED DESCRIPTION

[0013] A poly(arylene ether) composition comprises a first poly(arylene ether) resin having an intrinsic viscosity greater than or equal to about 0.3 dl/g, as measured in chloroform at 25°C and a second poly(arylene ether) resin having an intrinsic viscosity less than or equal to about 0.17 dl/g, as measured in chloroform at 25°C wherein the composition is essentially free of plasticizers. "Essentially free" is herein defined as containing less than about 1 weight percent (wt%), preferably less than about 0.5 wt% and more preferably 0 wt% plasticizers, wherein the amount of plasticizer is based on the total weight of the composition.

[0014] The poly(arylene ether) composition described herein, has a heretofore unknown combination of low melt viscosity and a high heat deflection temperature.

[0015] The composition in the absence of filler typically exhibits a melt viscosity at 1500 seconds⁻¹ and a temperature of 320 °C of less than or equal to about 190, preferably less than or equal to about 180, and more preferably less than or equal to about 170 Pascals-seconds as determined by multipoint capillary rheometry. The composition in the presence of filler typically exhibits a melt viscosity at 1500 seconds⁻¹ and a temperature of 320 °C of less than or equal to about 270, preferably less than or equal to about 250, and more preferably less than or equal to about 230 Pascals-seconds as determined by multipoint capillary rheometry.

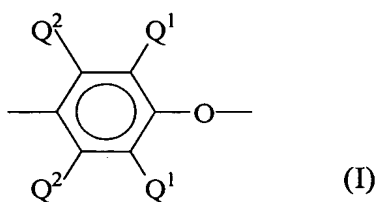
[0016] The composition in the presence or absence of filler has a heat deflection temperature at 264 pounds per square inch (psi) greater than or equal to about 130 °C, preferably greater than or equal to about 140 °C, more preferably greater than or equal to about 150 °C, and most preferably greater than or equal to about 165 °C as determined by ASTM D648. The combination of low melt viscosity and high heat deflection temperature have previously not been available in

poly(arylene ether) compositions. Previous low melt viscosity poly(arylene ether) compositions have employed a plasticizer which has limited the heat deflection temperature.

[0017] The composition may also exhibit a dissipation factor, measured according to ASTM D150 at 25°C and 1 kilohertz or 10 kilohertz or 100 kilohertz or 1 megahertz, of less than or equal to about 0.02, preferably less than or equal to about 0.01, more preferably less than or equal to about 0.005. In one embodiment, the cured composition exhibits dissipation factors, measured according to ASTM D150 at 25°C, of less than or equal to 0.005 at each of 1 kilohertz, 10 kilohertz, 100 kilohertz, and 1 megahertz.

[0018] The composition may also exhibit an improved dielectric strength, measured according to ASTM D149. For example, a composition comprising 90 weight percent poly(arylene ether) having an intrinsic viscosity of 0.4 dl/g as measured in chloroform at 25°C and 10 weight percent poly(arylene ether) having an intrinsic viscosity of 0.12 dl/g as measured in chloroform at 25°C has a mean dielectric strength value of 28 kilovolts per millimeter (kv/mm) with standard deviation of 2.02 kv/mm. For comparison, a composition comprising 90 weight percent poly(arylene ether) having an intrinsic viscosity of 0.4 dl/g as measured in chloroform at 25°C and 10 weight percent polystyrene has a mean dielectric strength value of 25.6 kv/mm with standard deviation of 1.37 kv/mm. Weight percent for the tested composition was based on the total weight of the composition.

[0019] The term poly(arylene ether) includes polyphenylene ether (PPE) and poly(arylene ether) copolymers; graft copolymers; poly(arylene ether) ether ionomers; and block copolymers of alkenyl aromatic compounds, vinyl aromatic compounds, and poly(arylene ether), and the like; and combinations comprising at least one of the foregoing; and the like. Poly(arylene ether)s per se, are known polymers comprising a plurality of structural units of the formula (I):



wherein for each structural unit, each Q^1 is independently hydrogen, halogen, primary or secondary lower alkyl (e.g., alkyl containing up to 7 carbon atoms), phenyl, haloalkyl, aminoalkyl, hydrocarbonoxy, halohydrocarbonoxy wherein at least two carbon atoms separate the halogen and oxygen atoms, or the like; and each Q^2 is independently hydrogen, halogen, primary or secondary lower alkyl, phenyl, haloalkyl, hydrocarbonoxy, halohydrocarbonoxy wherein at least two carbon atoms separate the halogen and oxygen atoms, or the like. Preferably, each Q^1 is alkyl or phenyl, especially C_{1-4} alkyl, and each Q^2 is hydrogen.

[0020] Both homopolymer and copolymer poly(arylene ether) are included. The preferred homopolymers are those containing 2,6-dimethylphenylene ether units. Suitable copolymers include random copolymers containing, for example, such units in combination with 2,3,6-trimethyl-1,4-phenylene ether units or copolymers derived from copolymerization of 2,6-dimethylphenol with 2,3,6-trimethylphenol. Also included are poly(arylene ether) containing moieties prepared by grafting vinyl monomers or polymers such as polystyrenes, as well as coupled poly(arylene ether) in which coupling agents such as low molecular weight polycarbonates, quinones, heterocycles and formals undergo reaction in known manner with the hydroxy groups of two poly(arylene ether) chains to produce a higher molecular weight polymer. Poly(arylene ether)s further include combinations comprising at least one of the above.

[0021] The poly(arylene ether) composition utilizes two poly(arylene ether)s. The first poly(arylene ether) resin has an intrinsic viscosity greater than about 0.30 dl/g, as measured in chloroform at 25°C. These polymers generally have more than 50 repeating units of Formula I above and a number average molecular weight within the range of about 3,000 to 40,000 and a weight average molecular weight in the range of 20,000 to 80,000, as determined by gel permeation chromatography. The

second poly(arylene ether) resin has an intrinsic viscosity of less than or equal to about 0.17 dl/g, preferably less than or equal to about 0.15 dl/g, and more preferably less than or equal to about 0.13 dl/g, as measured in chloroform at 25°C. The terms first and second as used herein with reference to poly(arylene ether)s are employed simply as identifiers and are not meant to imply or require a particular order of addition. The first and second poly(arylene ether) resins may have the same or different chemical structure.

[0022] The poly(arylene ether) are typically prepared by the oxidative coupling of at least one monohydroxyaromatic compound such as 2,6-xyleneol or 2,3,6-trimethylphenol. Catalyst systems are generally employed for such coupling; they typically contain at least one heavy metal compound such as a copper, manganese or cobalt compound, usually in combination with various other materials.

[0023] Particularly useful poly(arylene ether)s for many purposes are those, which comprise molecules having at least one aminoalkyl-containing end group. The aminoalkyl radical is typically located in an ortho position to the hydroxy group. Products containing such end groups may be obtained by incorporating an appropriate primary or secondary monoamine such as di-n-butylamine or dimethylamine as one of the constituents of the oxidative coupling reaction mixture. Also frequently present are 4-hydroxybiphenyl end groups, typically obtained from reaction mixtures in which a by-product diphenoquinone is present, especially in a copper-halide-secondary or tertiary amine system. A substantial proportion of the polymer molecules, typically constituting as much as about 90% by weight of the polymer, may contain at least one of said aminoalkyl-containing and 4-hydroxybiphenyl end groups.

[0024] It will be apparent to those skilled in the art from the foregoing that the contemplated poly(arylene ether) include many of those presently known, irrespective of variations in structural units or ancillary chemical features.

[0025] The weight ratio of the first poly(arylene ether) the second poly(arylene ether) in the poly(arylene ether) composition can vary widely and is

preferably greater than about 1:1 and more preferably greater than about 1.25:1. Weight ratios of about 1:5 to about 20:1 are even more preferred and ratios of about 9:1 to about 2:1 are most preferred. At high concentrations, the second poly(arylene ether) resin provides brittle materials. Therefore, the second poly(arylene ether) resin is preferably used in an amount of about 40 weight percent (wt%) or less of the total composition, more preferably about 1 to about 30 wt% of the total composition and most preferably about 3 to about 25 wt% of the total composition.

[0026] The poly(arylene ether) composition may comprise other components in amounts that vary widely. Most often the combination of first and second poly(arylene ether) is employed in an amount of about 5 to 95 wt% and preferably about 50 to 95 wt% by weight, based on the total weight of the composition. However, compositions comprising 100 wt% poly(arylene ether) are specifically contemplated.

[0027] In certain embodiments, the poly(arylene ether) composition may comprise polyamides as disclosed in U.S. Patent Nos. 5,981,656 and 5,859,130, polyarylene sulfides as disclosed in U.S. Patent No. 5,290,881, polyphthalamides as disclosed in U.S. Patent No. 5,916,970, polyetheramides as disclosed in U.S. Patent No. 5,231,146, polyesters as disclosed in U.S. Patent No. 5,237,005, polyetherimides and combinations of the foregoing.

[0028] The poly(arylene ether) composition may further comprise additives such as impact modifiers, antioxidants, fillers, conductive fillers (e.g., conductive carbon black, carbon fibers, stainless steel fibers, metal flakes, metal powders, and the like) reinforcing agents (e.g., glass fibers), stabilizers (e.g., oxidative, thermal and ultraviolet stabilizers), antistatic agents, lubricants, colorants, dyes, pigments, drip retardants, and mold release agents.

[0029] Materials which enhance the impact strength of the poly(arylene ether) composition (impact modifiers) are not critical but are often desirable. Suitable materials include natural and synthetic elastomeric polymers such as natural rubbers, synthetic rubbers and thermoplastic elastomers. They are typically derived from

monomers such as olefins (e.g., ethylene, propylene, 1-butene, 4-methyl-1-pentene) alkenylaromatic monomers, (e.g., styrene and alphanethyl styrene) conjugated dienes (e.g., butadiene, isoprene and chloroprene) and vinylcarboxylic acids and their derivatives (e.g., vinylacetate, acrylic acid, alkylacrylic acid, ethylacrylate, methyl methacrylate acrylonitrile). They may be homopolymers as well as copolymers including random, block, graft and core shell copolymers derived from these various suitable monomers discussed more particularly below.

[0030] Polyolefins which can be included within the poly(arylene ether) composition are of the general structure: C_nH_{2n} and include polyethylene, polypropylene and polyisobutylene with preferred homopolymers being polyethylene, LLDPE (linear low density polyethylene), HDPE (high density polyethylene) and MDPE (medium density polyethylene) and isotactic polypropylene. Polyolefin resins of this general structure and methods for their preparation are well known in the art and are described for example in U.S. Patent Nos. 2,933,480, 3,093,621, 3,211,709, 3,646,168, 3,790,519, 3,884,993, 3,894,999, 4,059,654, 4,166,055 and 4,584,334.

[0031] Copolymers of polyolefins may also be used such as copolymers of ethylene and alpha olefins like propylene and 4-methylpentene-1. Copolymers of ethylene and C_3 - C_{10} monoolefins and non-conjugated dienes, herein referred to as EPDM copolymers, are also suitable. Examples of suitable C_3 - C_{10} monoolefins for EPDM copolymers include propylene, 1-butene, 2-butene, 1-pentene, 2-pentene, 1-hexene, 2-hexene and 3-hexene. Suitable dienes include 1,4 hexadiene and monocyclic and polycyclic dienes. Mole ratios of ethylene to other C_3 - C_{10} monoolefin monomers can range from 95:5 to 5:95 with diene units being present in the amount of from 0.1 to 10 mol%. EPDM copolymers can be functionalized with an acyl group or electrophilic group for grafting onto the poly(arylene ether) as disclosed in U.S. Patent No. 5,258,455.

[0032] Polyolefins are typically present in an amount from about 0.1% to about 10% by weight based on the total weight of the composition. Where the polyolefin is an EPDM, the amount is generally from 0.25% by weight to about 3% by weight of the composition.

[0033] Suitable materials for impact modification include conjugated diene homopolymers and random copolymers. Examples include polybutadiene, butadiene-styrene copolymers, butadiene-acrylate copolymers, isoprene-isobutene copolymers, chlorobutadiene polymers, butadiene acrylonitrile polymers and polyisoprene. These impact modifiers may comprise from about 1 to 30 weight percent of the total composition.

[0034] A particularly useful class of impact modifiers with conjugated dienes comprises the AB (di-block), $(AB)_m-R$ (di-block) and ABA' (tri-block) block copolymers. Blocks A and A' are typically alkenyl aromatic units and Block B is typically conjugated diene units. For block copolymers of the formula $(AB)_m-R$, integer m is at least 2 and R is a multifunctional coupling agent for the blocks of the structure AB.

[0035] Also useful are core shell graft copolymers of alkenylaromatic and conjugated diene compounds. Especially suitable are those comprising styrene blocks and butadiene, isoprene or ethylene-butylene blocks. Suitable conjugated diene blocks include the homopolymers and copolymers described above which may be partially or entirely hydrogenated by known methods, whereupon they may be represented as ethylene-propylene blocks or the like and have properties similar to those of olefin block copolymers. The suitable alkenyl aromatics include styrene, alpha-methyl styrene, para-methyl styrene, vinyl toluene, vinyl xylene and vinyl naphthalene. The block copolymer preferably contains from about 15 to 50% alkenyl aromatic units. Examples of triblock copolymers of this type are polystyrene-polybutadiene-polystyrene (SBS), hydrogenated polystyrene-polybutadiene-polystyrene (SEBS), polystyrene-polyisoprene-polystyrene (SIS) and poly(alpha-methylstyrene)-polyisoprene - poly(alpha-methylstyrene). Examples of commercially available triblock copolymers are the CARIFLEX®, KRATON® D and KRATON® G series from Shell Chemical Company.

[0036] Also included are impact modifiers comprising a radial block copolymer of a vinyl aromatic monomer and a conjugated diene monomer. Copolymers of this type generally comprise about 60 to 95 wt% polymerized vinyl

aromatic monomer and about 40 to 5 wt% polymerized conjugated diene monomer. The copolymer has at least three polymer chains which form a radial configuration. Each chain terminates in a substantially non-elastic segment, to which the elastic polymer segment is joined. These block copolymers are sometimes referred to as "branched" polymers as described in U.S. Patent No. 4,097,550 and are used in amounts analogous to other conjugated diene based impact modifiers.

[0037] Materials useful in improving the impact strength of the composition are typically employed in amounts of about 2 to about 10 weight percent, based on the total weight of the composition.

[0038] It has been found that the advantages of employing low intrinsic viscosity poly(arylene ether) resins as discussed above are also provided in fiber reinforced poly(arylene ether) compositions. Reinforcing agents include fibrous and non-fibrous fillers. The poly(arylene ether) composition may contain fiber reinforcement such as glass fibers which greatly increases the flexural strength, dimensional stability and modulus as well as the tensile strength of the molded composition obtained therewith. In general, lime-aluminum borosilicate glass that is relatively soda-free ("E" glass) is preferred. Although glass roving may be used, cut fibers and milled fibers are often preferred. The length of such cut fibers is usually at least 3 millimeters (mm) and milled fibers would be less than or equal to about 1.5 mm. A preferred length is about 3 mm to about 13 mm. A preferred diameter of the fibers is about 0.002 mm to about 0.015 mm (i.e. 15 micrometers). The amount of glass fiber employed is 0 to about 60% by weight of the total composition and is preferably about 3% to about 30% by weight based on the weight of the entire composition. Larger amounts are used where the end use requires a higher degree of stiffness and strength. More preferably, the amount of glass fiber is about 6% to about 25% by weight based on the weight of the entire composition.

[0039] Carbon fibers, carbon fibrils, carbon powder, Kevlar® fibers, stainless steel fibers, and metal coated graphite fibers can also be employed at levels of 0 to about 60 wt%, preferably about 1.5 to about 25 wt%, more preferably about 3% to about 15% by weight. Carbon fibers typically have a length of at least 3mm,

preferably about 3mm to about 13 mm. Samples of metal used to coat the graphite fibers include nickel, silver, brass, copper and gold, with nickel being preferred. Fibers and platelets of metals such as aluminum, nickel, iron and bronze are also suitable in amounts up to about 60 wt% based on the entire weight of the composition.

[0040] Suitable non-fibrous inorganic fillers include mica, clay, glass beads, glass flakes, graphite, aluminum hydrate, calcium carbonate, silica, kaolin, barium sulfate, talcum and calcium silicate (wollastonite). Effective amounts will differ according to the particular agent used, but they are generally about 0.25% to about 60 wt%, more typically about 1 to about 30 wt% and preferably about 3% to about 12% by weight based on the weight of the entire composition. Examples of mica include muscovite, phlogopite, biotite, fluorophlogopite, and synthetic mica. When utilized, the levels of mica are preferably about 0.25% to about 30% by weight, based on the weight of the entire composition. When utilized, the preferred amounts of clay are about 0.25% to about 30% by weight, based on the weight of the entire composition.

[0041] Suitable pigments include those well known in the art such as titanium dioxide (TiO_2), and carbon black. Suitable stabilizers include zinc sulfide, zinc oxide and magnesium oxide.

[0042] Suitable antioxidants include, but are not limited to, hydroxyl amines, hindered phenols such as alkylated monophenols and polyphenols, benzofuranones such as 3 aryl benzofuranone, alkyl and aryl phosphites such as 2,4-di-tert butyl phenol phosphite and tridecyl phosphite, and hindered amines such as dioctyl methylamine oxide and other tertiary amine oxides. Such antioxidants are preferably used in an amount of 0.1 to 1.5 wt%, based on the weight of the composition.

[0043] Suitable U.V. stabilizers include 4,6- dibenzoyl resorcinols, alkanol amine morpholones and benzotriazole.

[0044] The poly(arylene ether) composition may be prepared by well known procedures. An example of a method of preparation is to first dry blend the first and second poly(arylene ether)s and compound the mixture by known techniques such as within an extruder to form the poly(arylene ether) composition. Additional

components such as fillers may be added with the poly(arylene ethers) or added at a subsequent mixing or compounding step. The poly(arylene ether) composition has lower melt viscosity while giving higher HDT values and impact properties when compared to previously known poly(arylene ether) compositions containing plasticizer. The poly(arylene ether) composition can be blended with other components or extruded, quenched and chopped into pellets. These pellets can then be melted and molded into articles of desired shape and size or compounded again to blend with other components before additional processing in preparing finished articles.

[0045] The poly(arylene ether) composition is particularly useful in the formation of electronic packaging handling systems such as integrated circuit trays and head gimbal assembly trays. Materials employed in electronic packaging handling systems require excellent dimensional stability, particularly at temperatures greater than about 130°C and in some applications at temperatures greater than or equal to about 150 °C.

[0046] The invention is further illustrated by the following non-limiting examples.

EXAMPLES 1-6

[0047] SA120, a poly(arylene ether) having an intrinsic viscosity of 0.12 g/dl measured in chloroform at 25°C was obtained from GE Plastics in pellet form and ground to reduce the particle size. 20 wt% ground SA120 was then melt blended with 80 wt% of higher intrinsic viscosity poly(arylene ether) (as shown in Table 2). The comparative examples employ 20 wt% crystal polystyrene (XPS) employed as a flow promoter/plasticizer. The melt viscosity of the examples was measured by multipoint capillary rheometry on a Kayeness Rheometer at 340°C using a 4 minute dwell time. Values for the shear rate are in reciprocal seconds and for melt viscosity are in Pascal-seconds. The data is shown in Figure 1 and Table 2. Figure 1 demonstrates the remarkably similar viscosity between compositions containing low intrinsic viscosity poly(arylene ether) (SA120) and comparable compositions containing a polystyrene

plasticizer. The heat deflection temperature (in °C) was measured at 264 psi using ASTM D648 and the data is shown in Figure 2.

Table 1

Example	1	2	3	4*	5*	6*
SA120	X	X	X			
Novacore 2272				X	X	X
Polyarylene ether (IV=0.30)	X			X		
Polyarylene ether (IV=0.40)		X			X	
Polyarylene (IV=0.46)			X			X

*Comparative examples

Table 2.

Shear	1	2	3	4*	5*	6*
48.6	367	999	1344	381	886	1114
97.3	347	816	1001	333	741	918
255.4	278	585	675	285	526	613
498.6	245	439	489	237	374	449
754	209	362	402	207	321	362
997.2	192	314	344	186	268	313
1495.8	164	255	276	155	215	254
1994.5	144	217	237	135	182	215
2505.2	129	190	207	121	172	188

*Comparative examples

[0048] As seen in Figure 1 and Table 2 the compositions containing the low intrinsic viscosity poly(arylene ether) (SA120) exhibit equivalent melt viscosity without the use of a plasticizer than comparable compositions containing polystyrene. Figure 2 demonstrates that compositions containing low intrinsic viscosity poly(arylene ether) exhibit significantly greater heat deflection temperatures than comparable compositions employing a flow promoter/plasticizer.

EXAMPLES 7-16

[0049] Examples 7-16 were prepared in the same manner as Examples 1-6. Examples 7-12 employ a high heat poly(arylene ether) that has an intrinsic viscosity of 0.33 g/dl measured in chloroform at 25°C. The amount of SA120 and crystal

polystyrene in the compositions was varied as shown in Table 3. The compositions were tested heat deflection temperature as described above. The melt viscosity of the examples was measured by multipoint capillary rheometry on a Kayeness Rheometer at 340°C using a 4 minute dwell time. Values for the shear rate are in reciprocal seconds and for melt viscosity are in Pascal-seconds. The data is shown in Tables 3 and 4 and Figure 3. Amounts of the components are shown in weight percent, based on the total weight of the composition.

Table 3

Example	0.33 IV PPO	SA120	HH PPO	XPS	HDT(in °C)
7	-	5	95	-	185
8	-	10	90	-	184
9	-	15	85	-	181
10	-	20	80		177
11*	-	-	95	5	177
12*	-	-	85	15	166
13	90	10	-	-	180
14	90	10	-	-	179
15	95	5	-	-	182
16*	95	-	-	5	177

*Comparative examples

Table 4

Shear	7	8	9	10	11*	12*	13	14	15	16*
97.3	605.8	521.9	464.5	348.6	623.5	414.3	247.9	203.6	263.8	242.6
206.7	467.3	421.2	373.9	287.1	492.4	340.1	209.1	192.5	238.3	223.3
304	425.2	380.5	335.2	253.8	446.2	303	189.2	174.5	213.6	206.2
498.6	348	314.3	283.8	222.8	368.5	259.3	168.6	157.9	191.7	184.5
705.4	300.4	278.8	246.1	195.7	315.3	223.9	150.9	145.1	173.9	168
997.2	256.8	232.7	214.7	171.4	270.4	193.7	139.1	133	158.1	154.4
1495.8	214.7	199.5	185	145.7	227.2	163.7	122.8	120.1	141.3	132.2
1994.5	191.3	179.6	160.4	129.1	200.3	144.32	109.3	108	124	119.9
2505.2	171.1	164.2	143.8	116	183.4	127.9	99	98.2	113.2	107.7
3003.8	159.4	152	133.1	106.7	168.8	118.7	92.9	92.2	105.2	101.3

*Comparative examples

[0050] As can be seen in Tables 3 and 4 and Figure 3 the replacement of crystal polystyrene with low intrinsic viscosity poly(arylene ether) results in a marked increase in heat deflection temperature while exhibiting a similar melt viscosity to compositions containing crystal polystyrene.

EXAMPLES 17-23

[0051] Examples 17-23 employ the materials described above as well as 0.5 parts by weight polyethylene, 11 parts by weight glass fiber, and 7 parts by weight carbon fiber, wherein the parts by weight are based on 100 parts of poly(arylene ether). The glass fiber employed is available under the trade name 122Y-14P from Owens Corning. The carbon fiber employed is available under the trade name Fortafil 202 from Akzo. The polyethylene was employed as a mold release agent and is available under the trade name G12024A from Novapol.

[0052] The compositions of the Examples 17-23 are shown in Table 4. The examples were tested for mold transfer pressure using a standard shot size, transfer position and injection speed. The examples were tested for heat deflection temperature at 264 psi and 66 psi according to ASTM D648, tensile strength according to ASTM D638, flex modulus according to ASTM D790, notched Izod according to ASTM D256, unnotched Izod according to ASTM D4812, and melt viscosity using multipoint capillary rheometry. Heat deflection temperatures are in °C. Tensile strength, mold transfer pressure, and flexural modulus are in megapascals (mpa). Notched and unnotched Izod values are in kilojoules per square meter (kJ/m²). Data for Examples 17-23 is shown in Table 5 and in Figures 4 and 5.

Table 5.

Ex	HH PPO	0.33 dl/g poly(arylene ether)	SA120	XPS	Mold transfer pressure	HDT (264 psi, °C)	HDT (66 psi, °C)	Tensile strength	Flex Mod	Notched Izod	Unnotched Izod
17*	-	80	-	20	4.6	172	178	91	8176	4.0	22.1
18	-	80	20	-	4.7	193	199	90	7762	4.1	29.0
19	-	90	10	-	6.1	198	205	87	7597	4.5	24.8
20	90	-	10	-	12.1	202	204	96	7849	5.1	27.9
21	80	-	20	-	10.2	199	208	88	7693	3.8	27.9
22	-	70	30	-	-	179	-	-	7723	3.9	-
23	-	60	40	-	-	-	-	84	7865	3.9	-

*Comparative examples

[0053] As can be seen from Table 4 and Figures 4 and 5 the replacement of polystyrene with low intrinsic viscosity poly(arylene ether) in filled compositions yields a unique combination of properties, namely melt viscosity similar to the melt viscosity of the polystyrene containing composition and a heat deflection temperature significantly higher than the polystyrene containing compositions.

EXAMPLES 24-38

[0054] SA120, a poly(arylene ether) having an intrinsic viscosity of 0.12g/dl measured in chloroform at 25°C was obtained from GE Plastics in pellet form and ground to reduce the particle size. The ground SA120 was melt blended with a poly(arylene ether) (PPO) having an intrinsic bisphenol A diphosphate (BPADP) in the amounts shown in Table 6. All amounts are in weight percent based on the composition total weight. The melt viscosity of the examples was measured by multipoint capillary rheometry on a Kayeness Rheometer at 300°C using a 4 minute dwell time. Values for the shear rate are in reciprocal seconds and for melt viscosity in Pascal-seconds. The examples were tested for heat deflection temperature at 264 psi according to ASTM D648, tensile strength according to ASTM D638 and flex modulus according to ASTM D790. The data is shown in Table 6. Heat deflection temperature values are in °C. Tensile yield strength values are in kilogram-force/square centimeter (kgf/cm²). Crosshead breaks elongation is in percent. Flexural modulus and flexural yield strength values are in kgf/cm².

Table 6.

	24*	25*	26*	27*	28*	29*	30*	31*	32*	33*	34*	35*	36*	37	38
PPO	69.5	78.5	66	82	57	66	61.5	86.5	80.25	67.75	91	82	57	80	70
SA120	17.5	17.5	30	5	30	30	30	5	11.25	23.75	5	5	30	20	30
BPADP	13	4	4	13	13	4	8.5	8.5	8.5	8.5	4	13	13	-	-
Flexural Modulus	29880	28550	28634	28519	28288	28129	29009	28806	28258	28994	27321	28388	28600	26838	27573
Flexural Yield Strength	668	928	817	13178	337	813	555	1301	1292	600	1263	1320	375	1155	832
Heat Deflection Temperature	128	162	156	134	123	155	140	151	146	142	150	132	123	172	167
Tensile Yield Strength	463	625	534	812	268	440	365	788	796	651	723	794	279	771	258
Crosshead Break															
Elongation	3.75	5.40	4.81	7.83	2.03	3.84	2.99	7.82	7.98	5.58	7.02	7.68	2.13	8.32	2.93
Shear=1496	113	258.8	164	176.7	65.8	156.9	102.6	260.8	210.5	127.4	298.6	160.2	63.5	330	234.9

*Comparative Examples

[0055] As can be seen by the melt viscosity and heat deflection of examples 24-36 the introduction of BPADP significantly lowers the melt viscosity and the heat deflection temperature. In contrast similar compositions, examples 37 and 38, without the BPADP surprisingly exhibit good melt viscosity and higher heat deflection temperature.

[0056] While the invention has been described with reference to various embodiments, it will be understood by those skilled in the art that various changes may be made and equivalents may be substituted for elements thereof without departing from the scope of the invention. In addition, many modifications may be made to adapt a particular situation or material to the teachings of the invention without departing from essential scope thereof. Therefore, it is intended that the invention not be limited to the particular embodiment disclosed as the best mode contemplated for carrying out this invention, but that the invention will include all embodiments falling within the scope of the appended claims.

[0057] All cited patents and other references are incorporated herein by reference in their entirety.